

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | |
|---|------|------|---|---|-------------------|---|-------------|--------------|--|--|---|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | |

Work Order ID 88299

88299

Page 2

August-01-12 2:49:51 PM

Item ID: D4419-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Support Plate
 Start Date: 8/27/12 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 8/27/12 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|----------------|--------------------|--------------|---------------|---------------|------------------|----------------|
| 120 *120* QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | Smb 12/8/29 | (DAS 16 8-3) | 12/6/29 | 9 | | | |
| 130 *130* Packaging Packaging | Identify as per dwg & Stock Location: <u>108</u> Memo | 0.00 0.00 | | 5f | | 9 | | 8 | 12/8/29 |
| 140 *140* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | MLC 12/08/29 | MF 12-08-29 |

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| Training <input type="checkbox"/> | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
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Picklist Print

August-01-12 2:49:51 PM

Page 1

Work Order ID: 88299

Parent Item: D4419-3

Start Date: 8/27/12

Required Date: 8/27/12

Parent Item Name: Aft Support Plate

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304S11GA
304/316 0.125 Sheet

Purchased No

sf 272.6760

~~2.9103158~~
3.0

Jm 12-8-28

Location

Loc Qty

Loc Code

MAT020

272.676

121780

4.976

122521

267.7

122521

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

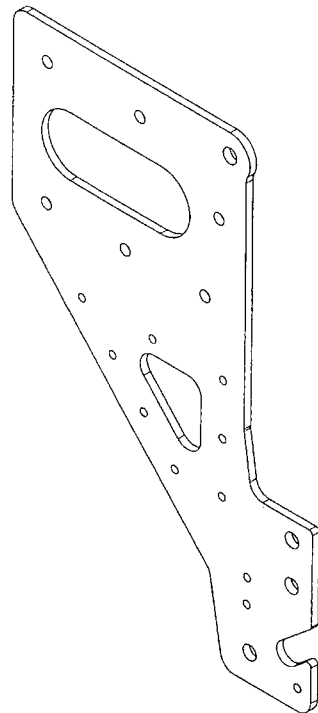
| | | | | | | | | | | | |
|--|-------------|-------------|------------|---|--------------------------|---|------------------------|---------------------|---------------------|--|--|
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| Training <input type="checkbox"/> | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | |

| FAULT CATEGORY | | | | | | | | | | | |
|---|--|--|---|--|--|---|--|--|--|--|---|
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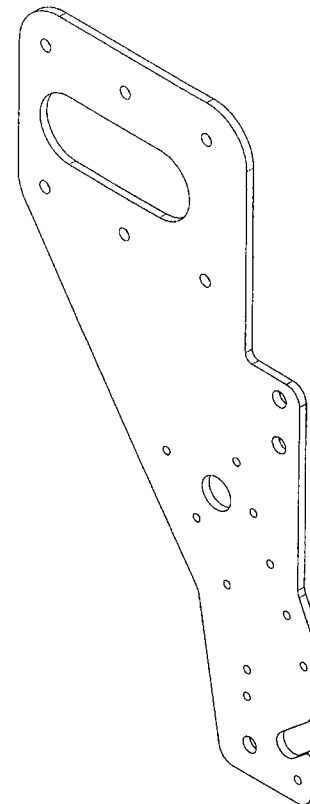
| | | | |
|--------------------------------|--|--------------|---------|
| DART AEROSPACE LTD | | Work Order: | 88299 |
| Description: Aft Support Plate | | Part Number: | D4419-3 |
| Inspection Dwg: D4419 Rev: A | | Page 1 of 2 | |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|------------|
| Ø0.129 | +0.005/-0.001 | 0.130" | ✓ | | ✓ | mm01 |
| Ø0.191 | +0.005/-0.001 | 0.191" | ✓ | | ✓ | |
| Ø0.250 | +0.005/-0.001 | 0.250" | ✓ | | ✓ | |
| Ø0.53 | +0.008/-0.001 | 0.530" | ✓ | | ✓ | |
| 5.55 | +/-0.030 | 5.562" | ✓ | | ✓ | |
| 5.27 | +/-0.030 | 5.285" | ✓ | | ✓ | |
| 4.25 | +/-0.030 | 4.268" | ✓ | | ✓ | |
| 2.80 | +/-0.030 | 2.796" | ✓ | | ✓ | |
| 0.40 | +/-0.030 | 0.412" | ✓ | | ✓ | |
| 3.83 | +/-0.030 | 3.831" | ✓ | | ✓ | |
| 5.56 | +/-0.030 | 5.568" | ✓ | | ✓ | |
| 6.26 | +/-0.030 | 6.259" | ✓ | | ✓ | |
| 7.14 | +/-0.030 | 7.140" | ✓ | | ✓ | |
| 7.73 | +/-0.030 | 7.730" | ✓ | | ✓ | |
| 0.31 | +/-0.030 | 0.318" | ✓ | | ✓ | |
| 0.38 | +/-0.030 | 0.386" | ✓ | | ✓ | |
| 0.750 | +/-0.010 | 0.754" | ✓ | | ✓ | |
| 1.53 | +/-0.030 | 1.541" | ✓ | | ✓ | |
| 0.390 | +/-0.010 | 0.393" | ✓ | | ✓ | |
| 0.450 | +/-0.010 | 0.455" | ✓ | | ✓ | |
| 1.67 | +/-0.030 | 1.670" | ✓ | | ✓ | |
| 10.55 | +/-0.030 | 10.560" | ✓ | | ✓ | Protractor |
| 8.00 | +/-0.030 | 8.000" | ✓ | | ✓ | |
| 6.02 | +/-0.030 | 6.036" | ✓ | | ✓ | |
| 1.10 | +/-0.030 | 1.085" | ✓ | | ✓ | |
| 1.20 | +/-0.030 | 1.213" | ✓ | | ✓ | |
| 0.50 | +/-0.030 | 0.503" | ✓ | | ✓ | |
| 1.500 | +/-0.010 | 1.504" | ✓ | | ✓ | 1 |
| 0.60 | +/-0.030 | 0.616" | ✓ | | ✓ | |
| 2.300 | +/-0.010 | 2.303" | ✓ | | ✓ | |
| 0.63 | +/-0.030 | 0.639" | ✓ | | ✓ | |
| 0.991 | +/-0.010 | 0.998" | ✓ | | ✓ | |
| 0.440 | +/-0.010 | 0.446" | ✓ | | ✓ | |



D4419-1 FWD SUPPORT PLATE



D4419-3 AFT SUPPORT PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
88299 MLJ
12/08/07

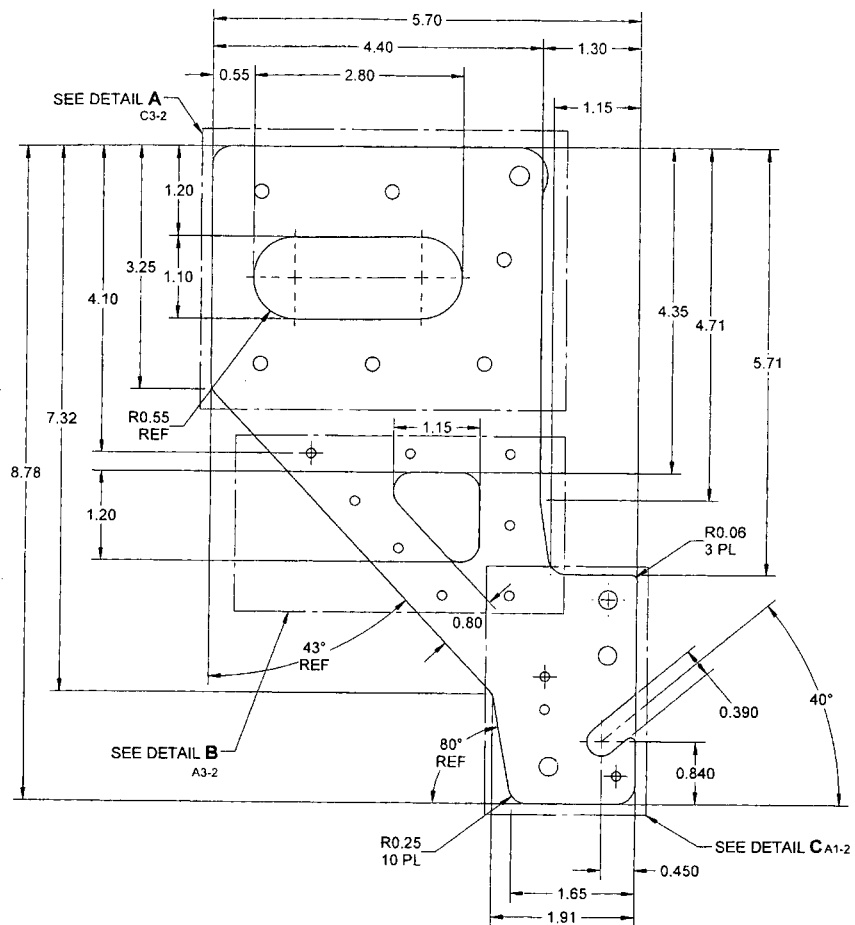
RELEASED
2011-07-28
JW

NOTES:

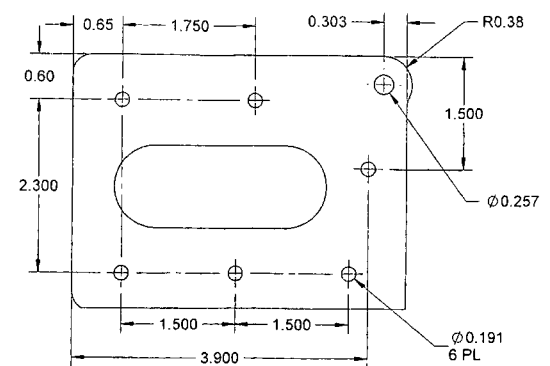
- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -1: 0.88 lbs
-3: 1.10 lbs

| A | NEW ISSUE | AJS | 11.07.06 |
|------------|-------------|--|--------------|
| REV | DESCRIPTION | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | JP | DRAWING NO. | REV. A |
| MFG. APPR. | E | D4419 | SHEET 1 OF 3 |
| APPROVED | JP | TITLE | SCALE |
| DE APPR. | JH | BASKET SUPPORT PLATES | NTS |
| DATE | 11.07.06 | <small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

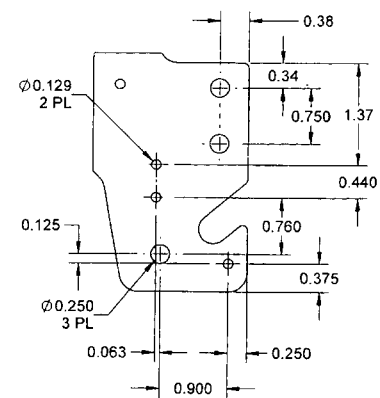
88299



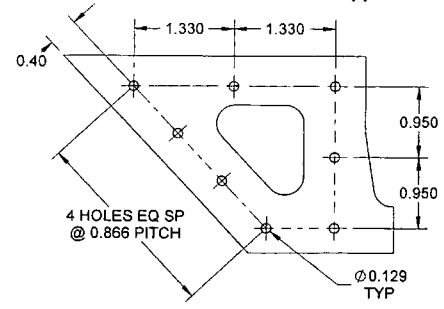
D4419-1 FWD SUPPORT PLATE



DETAIL A D8-2



DETAIL B B7-2

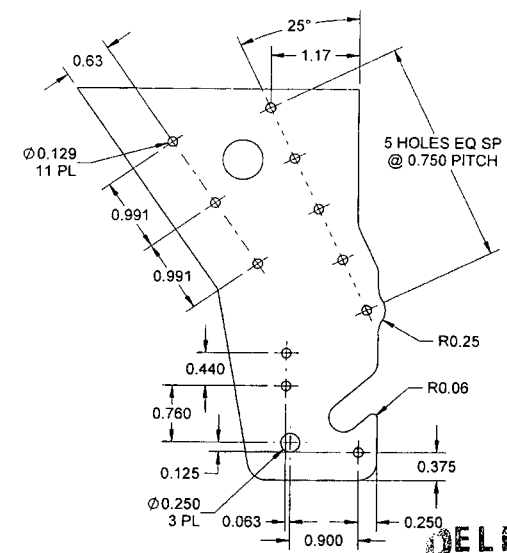
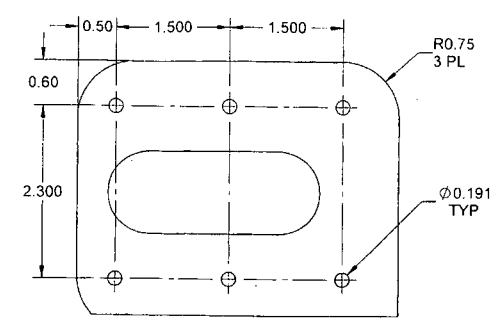
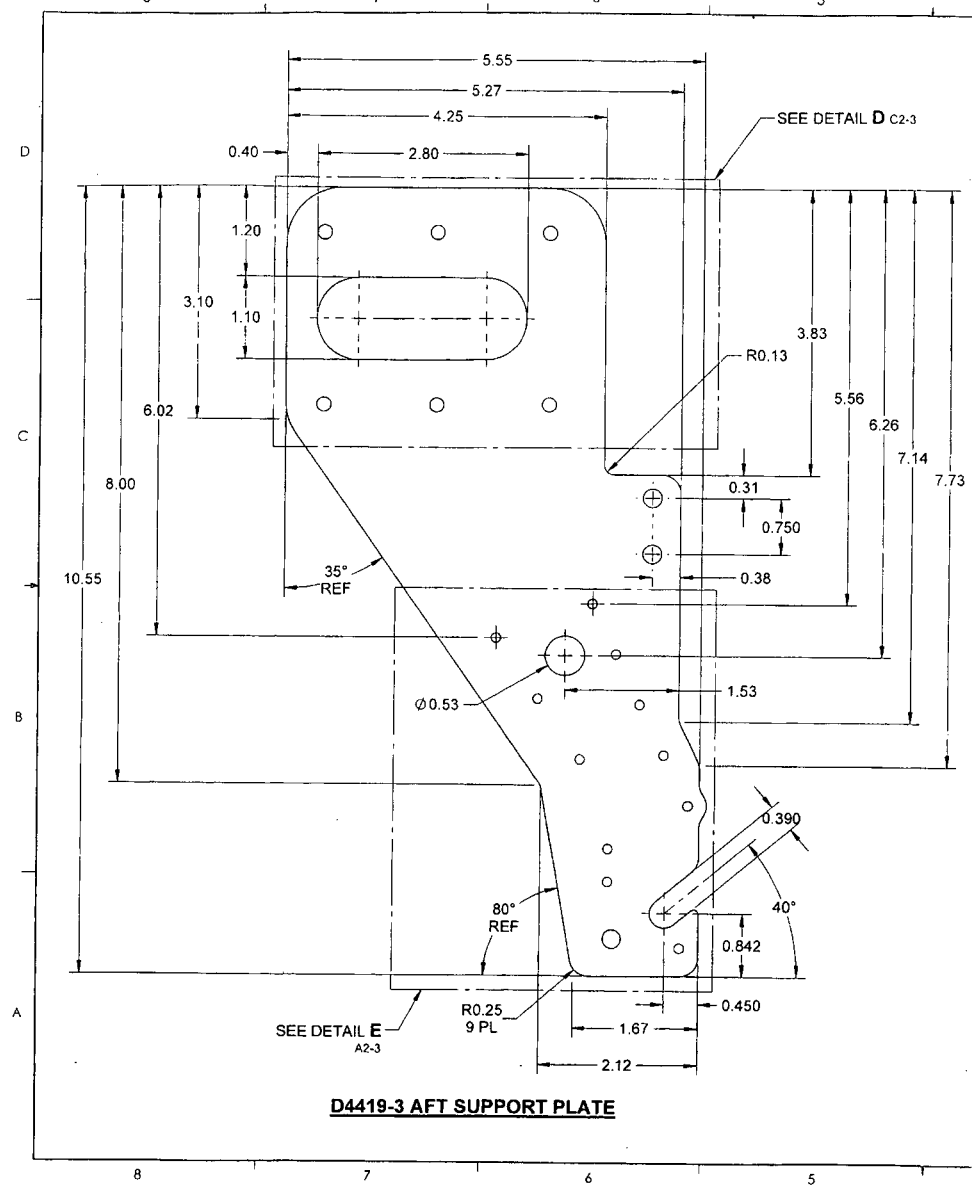


DETAIL C A4-2

RELEASED
2011-07-28

| | | | |
|--|-----------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>GP</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>BE</i> | D4419 | SHEET 2 OF 3 |
| APPROVED | <i>GP</i> | TITLE | SCALE |
| DE APPR. | <i>GP</i> | BASKET SUPPORT PLATES | NTS |
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88299



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2011-11-18

| | | | |
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| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. D4419 | REV. A |
| MFG. APPR. | <i>[Signature]</i> | SHEET 3 OF 3 | |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
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